

Split

Work Order ID 96245 ²

96245

U/R

Page 1

January-25-13 9:23:38 AM

Item ID: D3705-041
Revision ID: U/R OK 1/13/13
Item Name: Instrument Panel Assembly
Start Date: 2/04/13 Start Qty: 4.00
Required Date: 2/08/13 Req'd Qty: 4.00
Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

²
4
4

Approvals: Process Plan: MCT Date: 13-01-25 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3705

E

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- Assemble parts as per dwg D3705

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location

0.00

120

Packaging

Memo

0.00

Packaging

PPP
96064 1x
96802 1x

2 FF 13-02-07

DAS
15
2-08
1327

2

(13/2/7) (2)

Work Order ID 96245

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Item ID: D3705-041
 Revision ID: U/R
 Item Name: Instrument Panel Assembly

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Start Date: 2/04/13 Start Qty: 4.00 ***4***
 Required Date: 2/08/13 Req'd Qty: 4.00 ***4***

Cust Item ID:
 Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
 QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

ML 13-02-07
MF
13-2-07

Picklist Print

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Page 1

Work Order ID: 96245
Parent Item: D3705-041
Parent Item Name: Instrument Panel Assembly

Start Date: 2/04/13
Start Qty: 4.00

Required Date: 2/08/13
Required Qty: 4.00

Comments: IPP Rev:A new issue 08-05-30 DD verified by:ec
IPP rev:B 09-01-09 rev:C as per dwg DD verified by:ec
IPP Rev:C 09-01-15 rivet chg DD verified by:EC
NCR10-017 DD verified by:EC
IPP Rev:E as per dwg RevD DD 10.04.27 verified by:EC
DD VERF:JLM
IPP rev:D 10.04.21 washer chg per
IPP REV:F 12.12.03 REV PE1
IPP REV:G 13.01.15 AS PER DWG REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3335-1 Short Spring		Manufactured	No			100	Each	0.0000	1	4		9.6050	
D3705-043 Instrument Panel Weldment		Manufactured	No			100	Each	0.0000	1	4		LT 13/02/03	
D3705-5 Access Panel		Manufactured	No			100	Each	5.0000	1	4		FF 13-02-07	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST063	95132	5				4			
					54825	3							
					90127	2							
D3706-041 Lock Bracket Assembly		Manufactured	No			100	Each	0.0000	1	4		FF 13-02-07	
D3706-5 Pin		Manufactured	No			100	Each	3.0000	1	4		FT 13-02-07	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST063	94280	3				4			
					56914	3							
D3707-3 Mounting Lug		Manufactured	No			100	Each	7.0000	2	8		FF 13-02-07	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST063	96127	7				1			
					56915	7							



Picklist Print

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Work Order ID: 96245

Parent Item: D3705-041

Start Date: 2/04/13

Required Date: 2/08/13

Parent Item Name: Instrument Panel Assembly

Start Qty: 4.00

Required Qty: 4.00

AN3-3A Purchased No 100 Each 436.0000 2 8

Bolt

FF 13-02-07

Location Loc Qty Loc Code

ST350 436
123352 36
123831 200
124221 200

AN526C1032R6 Purchased No 100 Each 725.0000 4 16

Screw

FF 13-02-07

Location Loc Qty Loc Code

ST346 725
1892 725

AN960JD516 NAS1149D0563J Purchased No 100 Each 2.0000 1 4

Washer

FF 13-02-07

Location Loc Qty Loc Code

ST504 122452 2
1069059 2

CR1122-3-02.5 Purchased No 100 Each 195.0000 28 112

RIVET

FF 13-02-07

Location Loc Qty Loc Code

GA 124209 52
122518 52
ST327 143
122845 43
124259 100

MS171498 Purchased No 100 Each 42.0000 1 4

Spring Pin

FF 13-02-07

Location Loc Qty Loc Code

ST331 42
108521 42

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Picklist Print

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Page 3

Work Order ID: 96245
Parent Item: D3705-041
Parent Item Name: Instrument Panel Assembly

Start Date: 2/04/13

Required Date: 2/08/13

Start Qty: 4.00

Required Qty: 4.00

MS21075L3 Purchased No

100 Each 43.0000 14 56

FT 13-02-07

Location

Loc Qty

Loc Code

ST318

43

B124551 (7)

123832

43

21

MS24693-C272 Purchased No

100 Each 1.252 0000 4 16

FF 13-02-07

Location

Loc Qty

Loc Code

ST300

1252

17137

467

17831

519

9370

266

16

NAS1149D0332J Purchased No

100 Each 1.346.0000 2 8

FT 13-02-07

Location

Loc Qty

Loc Code

EP001

176

122973

176

ST294

1170

122973

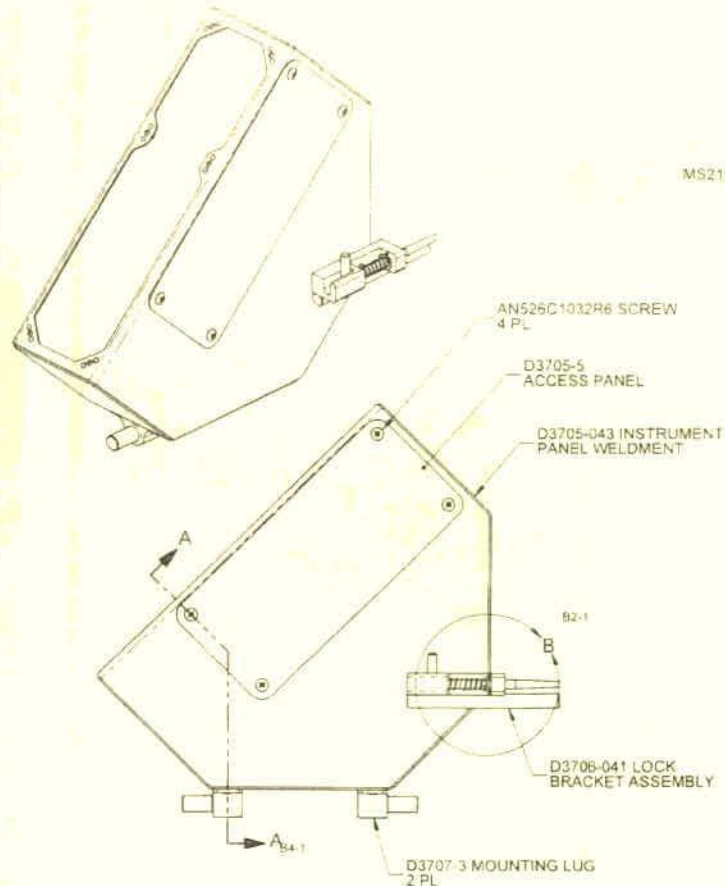
1170

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D3705-041 INSTRUMENT PANEL ASS'Y

D3705-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (PERMANENT INK MARKER)
- 7) WEIGHT: 3.20 lbs

MS21075L3 NUTPLATE REF

AN526C1032R6 SCREW 4 PL

D3705-5 ACCESS PANEL

D3705-043 INSTRUMENT PANEL WELDMENT

B2-1

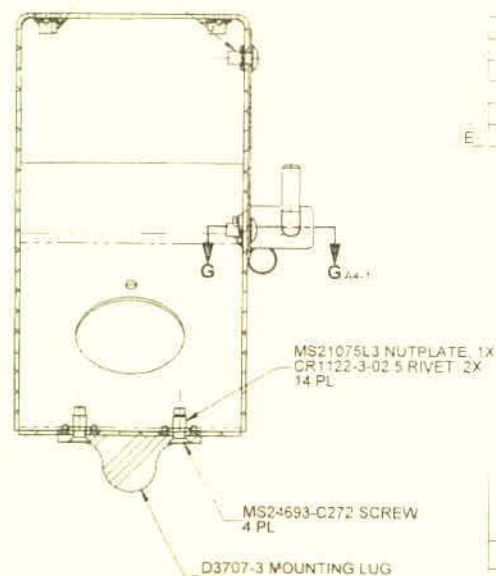
D3706-041 LOCK BRACKET ASSEMBLY

D3707-3 MOUNTING LUG 2 PL

AN3-3A BOLT
NAS1149D0332J WASHER 2 PL

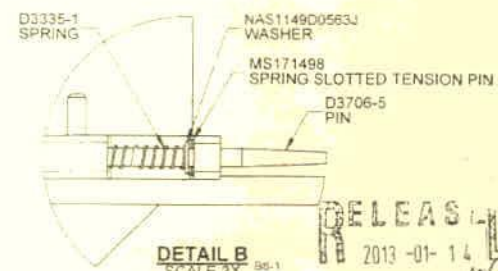


SECTION G-G SCALE 2X



SECTION A-A SCALE 2X

ITEM	QTY	P/N	DESCRIPTION
X	1	D3705-041	INSTRUMENT PANEL ASS'Y
1	1	D3335-1	SPRING
2	1	D3705-043	INSTRUMENT PANEL WELDMENT
3	1	D3705-5	ACCESS PANEL
4	1	D3706-041	LOCK BRACKET ASSEMBLY
5	1	D3706-5	PIN
6	2	D3707-3	MOUNTING LUG
7	2	AN3-3A	BOLT
8	4	AN526C1032R6	SCREW
9	1	NAS1149D0563J	WASHER (OR AN960JD516)
10	28	CR1122-3-02 5	RIVET
11	1	MS171498	SPRING SLOTTED TENSION PIN
12	14	MS21075L3	NUT PLATE
13	4	MS24693C272	SCREW
14	2	NAS1149D0332J	WASHER (OR AN960JD10L)



DETAIL B SCALE 2X

E	REVISED D3705-1/3 (NOW 0.75 TALLER - AFFECTS 1-F, 3-F). D3705-1/3 NOW D3706-041 AND BOLTED. ADD AN3-3A BOLT. NAS1149D0332J WASHER. D3706-041: 8.88 WAS 9.13 (ZN D3-3, B3-3, C7-4). 8.000 WAS 7.150 (ZN D4-6). 3.20 lbs WAS 3.00 lbs. REASON: CR12-4PAR12-188	MB	12.11.20
D	ITEM 14 WAS AN960JD416 (ZN D3-1 AND C1-1) REASON: NCR#10-017	MB	10.04.13
C	ADDED D3705-7/8-11 (SHEET 6). REMOVED MS35589-156 GROMMET. 9.31 AND 12.66 WERE 9.36 AND 12.61 (ZN B6-3). 2.130 WAS 1.50 (ZN D3-4). ADDED 0.0204 HOLE (ZN D3-4). CR1122-3-02 5 WAS MS20426AD3-3. REASON: COMPLETED DESIGN OF FACE PLATES REQUIRED TO MOUNT INSTRUMENTS	MB	08.11.20
B	ADDED MS35489-156. QTY 14 MS21075L3 WAS QTY 8. QTY 28 MS20426AD3-3 WAS QTY 16. MS171498 WAS TP-2. AN526C1032R6 WAS MS27035-109 & AN960JD10L (ZN D3-1). REDESIGNED D3705-1F FLAT PATTERN (ZN B6-3). REASON: GIVE MORE FLEXIBILITY TO CUSTOMER IN TERMS OF INSTRUMENT ARRANGEMENT	MB	08.08.07
A	NEW ISSUE	MB	08.05.28
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG APPR.			
APPROVED			
DE APPR.			
DATE	12.11.30		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3705** REV. E
SHEET 1 OF 6
TITLE **INSTRUMENT PANEL ASS'Y** SCALE NTS

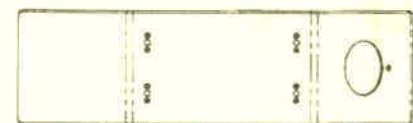
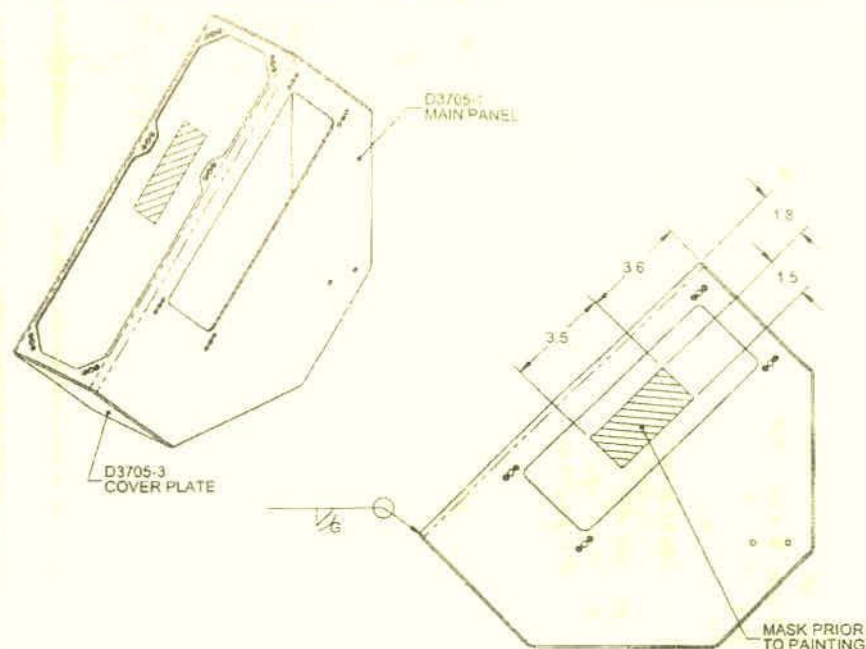
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90245 M.L.S.
1301-25



96245

ITEM	QTY	P.N.	DESCRIPTION
X		D3705-043	INSTRUMENT PANEL WELDMENT
1		D3705-1	MAIN PANEL
3		D3705-3	COVER PLATE



D3705-043 INSTRUMENT PANEL WELDMENT

RELEASED
2013-01-14

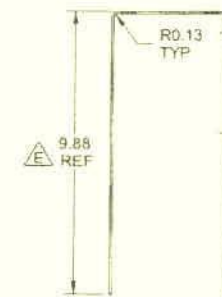
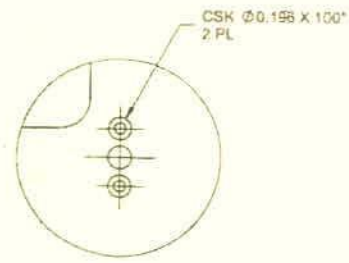
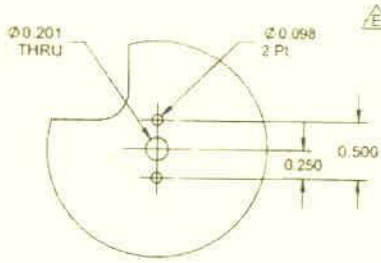
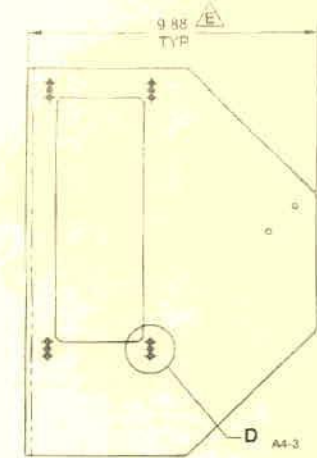
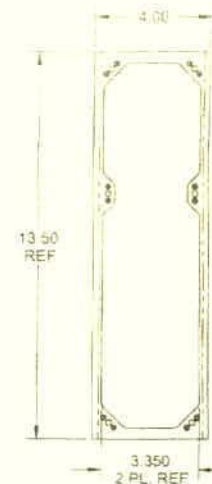
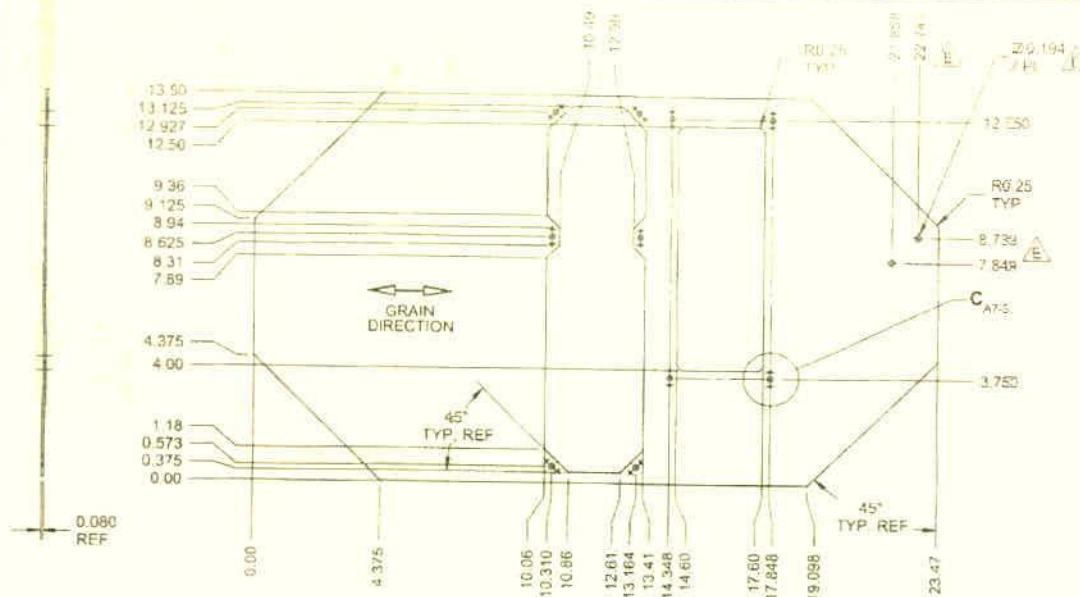
D3705-043 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.20 lbs
- 8) WELDING: PER DART QSI 004

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CHECKED		DRAWING NO. D3705	REV. E
MFG. APPR.			SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL ASS'Y	N/A
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8 7 6 5 4 3 2 1

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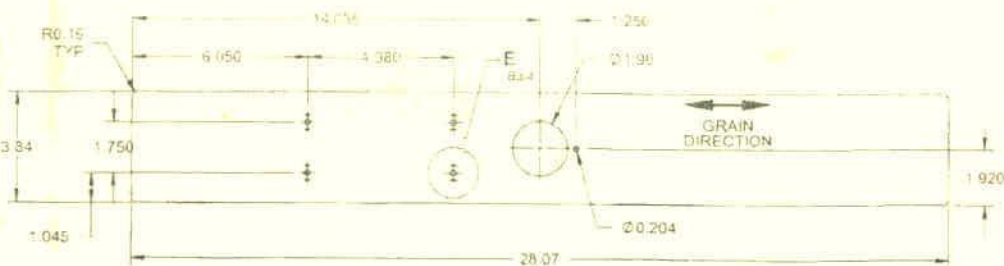


D3705-1 MAIN PANEL
MAKE FROM D3705-1F

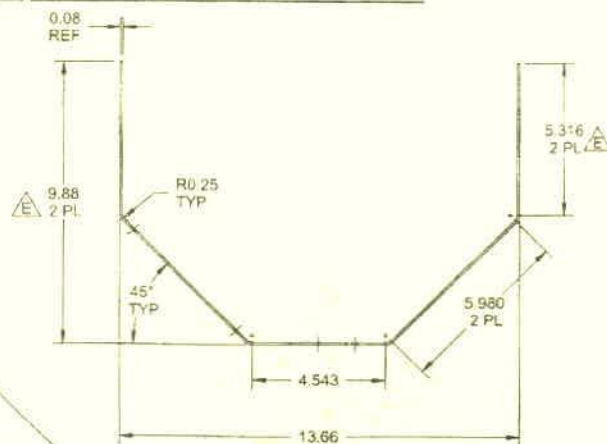
D3705-1F-1F NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.65 lbs

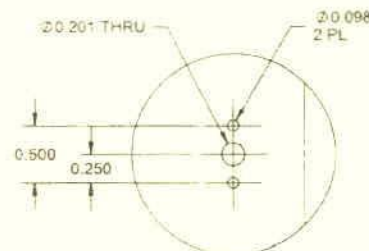
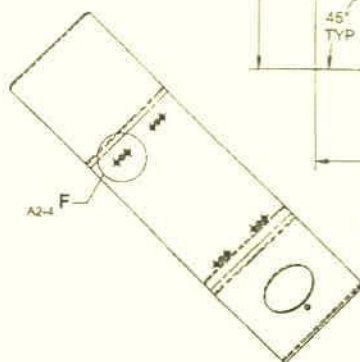
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DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3705	SHEET 3 OF 3
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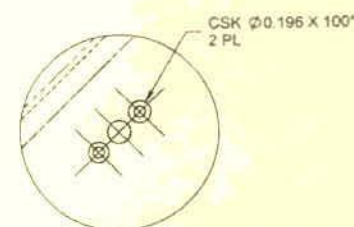
D3705-3F COVER PLATE FLAT PATTERN



**D3705-3 COVER PLATE
(MAKE FROM D3705-3F)**



**DETAIL D
SCALE 4X
4 PL**



**DETAIL F
SCALE 4X
4 PL**

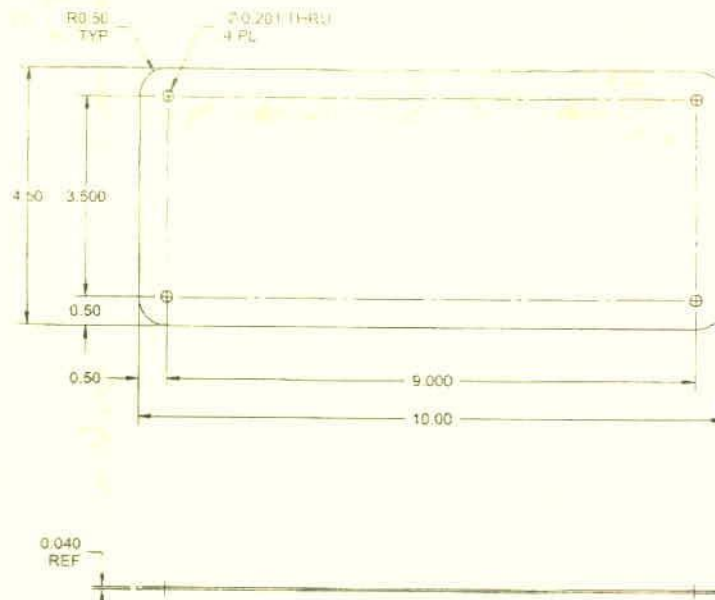
RELEASE
2013-01-14

D3705-3/3F NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.82 lbs

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3705	SHEET 4 OF 8
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96245



D3705-5 ACCESS PANEL

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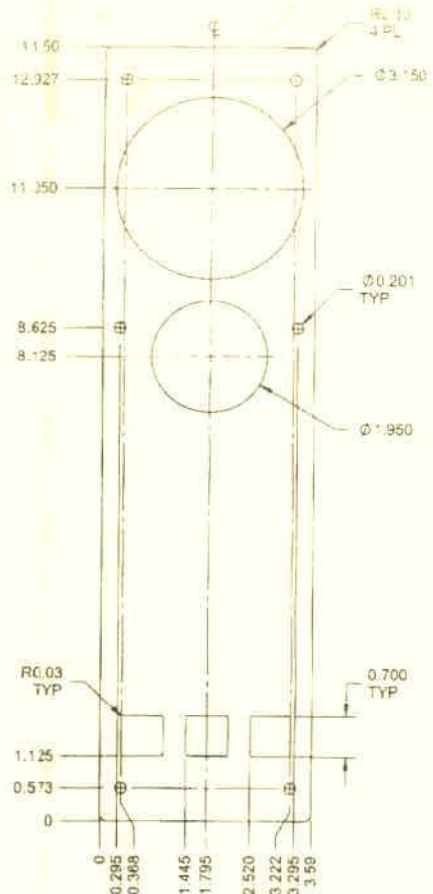
D3705-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (PERMANENT INK MARKER)
- 8) WEIGHT: 0.17 lbs

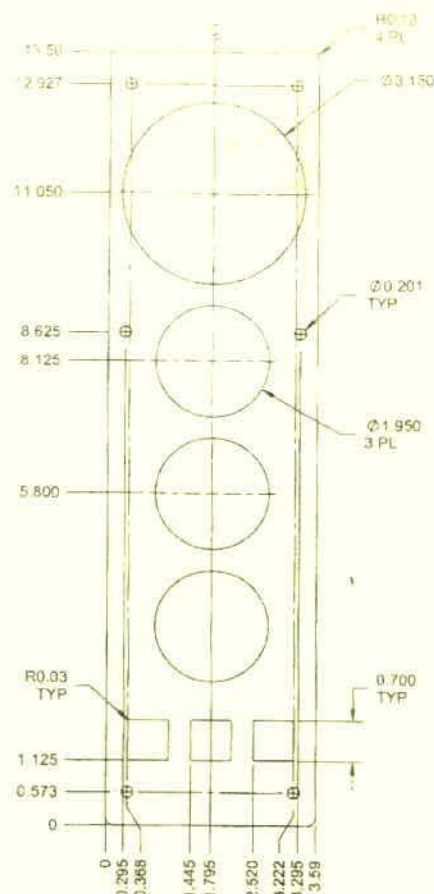
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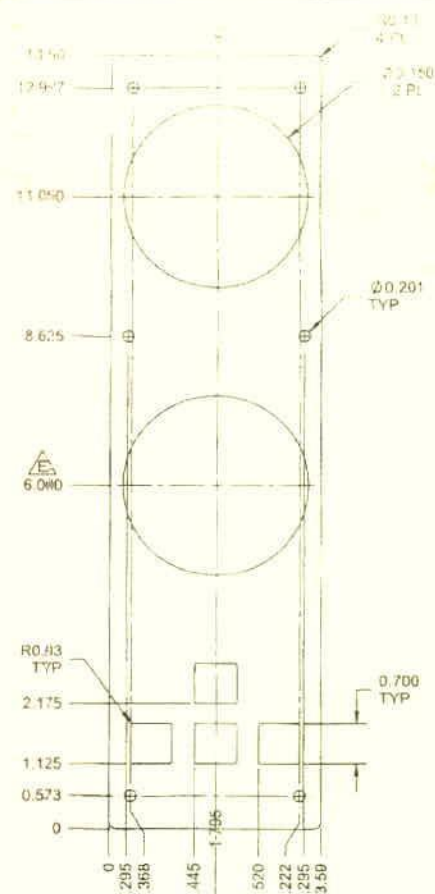
90245



D3705-7 FACE PLATE



D3705-9 FACE PLATE



D3705-11 FACE PLATE

**SIDE VIEW
TYP**

D3705-7/-9/-11 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M0061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (PERMANENT INK MARKER)
- 7) WEIGHT: D3705-7 = 0.22 lbs; D3705-9 = 0.18 lbs; D3705-11 = 0.19 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. E
CHECKED		D3705	SHEET 6 OF 20
MFG APPR.		TITLE	SCALE
APPROVED		INSTRUMENT PANEL ASS'Y	NR3
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